1.5 Tonne Welding Positioner User Manual and Specifications

1.5 Welding Positioner Specifications:

- **Load Capacity:** 1500kg @ 300mm away from a tilted 90° table & 750kg @ 600mm from a tilted 90° table (depending on eccentricity: off-centre load displacement weight distribution)
- **Machine Weight:** 900kg
- **Colour:** Spectrum Red
- **Supply:** 415V (32 Amp Plug)
- **Earthing Point Amperage Rating:** 600 Amps
- **Operation:** Fully motorized on table up, table down, forward and reverse
- **Controls:** Pendant controlled with 'Up, Down, Forward, Reverse, Stop and Variable Speed Potentiometer', as well as a non-latching foot pedal operation
- **Table Slots:** x6 slots
- **Additional Features:** x2 lifting eyes on either side, moving parts guards, x6 levelling bolts on feet.

User Manual:

Step by Step Process:

1. Plug the welding positioner into a 415V 32 Amp socket.

2. To turn on the welding positioner, turn the red & yellow circular on/off switch at the bottom of the white control panel (located on the side on the machine) clockwise.

3. The 'Power On' light at the top of the control box should now be on.

4. This machine is **'Phase Sensitive,'** meaning now the machine is turned on, when the operator presses 'Up' on the yellow pendant, the table should tilt **'Up.'** If the table tilts **'Down'** when pressing **'Up'** this means the machine is 'out of phase,' and will damage the limit switches if the table is tilted. The x3 phases in the 415V 32 Amp plug needs swapping over. To do this all that is required is that the machine be unplugged, open up the 32 Amp plug, and swap the 'L2' wire and 'L3' wire over in the plug. Now plug the welding positioner back in. When pressing **'Up'** the machine will now tilt **'Up.'**

5. When tilting the machine either 'Up' or 'Down' the table will only go so far until it reaches the 'limit switches,' which will prevent the table going any further.

6. After pressing 'Forward' or 'Reverse' on the yellow pendant control, the operator will now have to press down on the red foot pedal control in order for the table to start turning. To turn the table in the opposite direction, the operator must take their foot off the foot pedal, press 'Stop' on the yellow pendant to reset the contactors, then press **'Forward'** or **'Reverse.'**

7. There is an emergency stop button located on the front of the white control box should power ever need cutting off to the welding positioner.